

Work Order ID 55251

January 12, 2010 1:35:16 PM



Page 1

Item ID: D4047-043

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4047

PAT PA3

10/01/27

100



Large Fab

Memo

0.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

MF 10-1-18

Large Fab

Memo
 1- Cut as per dwg D4047-
 2- Drill and chamfer holes as per dwg D4047-
 3-remove identification markings
 4- Weld bushing in rib and grind weld flush as per dwg D4047

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00



0.00

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55251

January 12, 2010 1:35:16 PM

Page 2

Item ID:	D4047-043		Accept			Setup	Start		
Revision ID:									
Item Name:	Rib Assembly								
Start Date:	1/12/10	Start Qty:	1.00			Cust Item ID:			
Required Date:	1/25/10	Req'd Qty:	1.00			Customer:			
Reference:									
Approvals:	Process Plan:	Date:	Tooling:	Date:		Run	Start		
	QC:	Date:	SPC (Y/N):	Date:					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC	QC10- Inspect visual per QSI004- ground welds Identify as per dwg & Stock Location: <u> basket</u>	0.00 0.00	→ <u>10.01.17</u>						
130  Packaging	Memo								
140  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Handwritten notes:

- Line 1: QC10- Inspect visual per QSI004- ground welds
Identify as per dwg & Stock Location: basket
0.00
0.00
→ 10.01.17
- Line 2: 130
Packaging
0.00
0.00
Handwritten: 10.01.16 ①
- Line 3: 140
QC21- Final Inspection - Work Order Release
0.00
0.00
Handwritten: 10.01.30
MF 10-1-19

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 12, 2010 1:35:20 PM

Work Order ID: 55251



Parent Item: D4047-043



Parent Item Name: Rib Assembly

Start Date: 1/12/10

Required Date: 1/25/10

Comments: 1- assemble and weld as per dwg D3589 QSI004
IPP RevA: new issue DD 10/01/06 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	0.0000	2.0000		855257	DD 10/01/10
Bushing												
M304TS0.750W.049		Purchased	No			100	f	48.4054	2.0666			
304 SQ Tube .75x.75x.049W												

Warehouse
Location

Main Warehouse

MAT	48.4054	
103240	1.5816	
106604	4.9307	
107460	29.2779	
109087	12.6152	

2-0666 SM 10/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

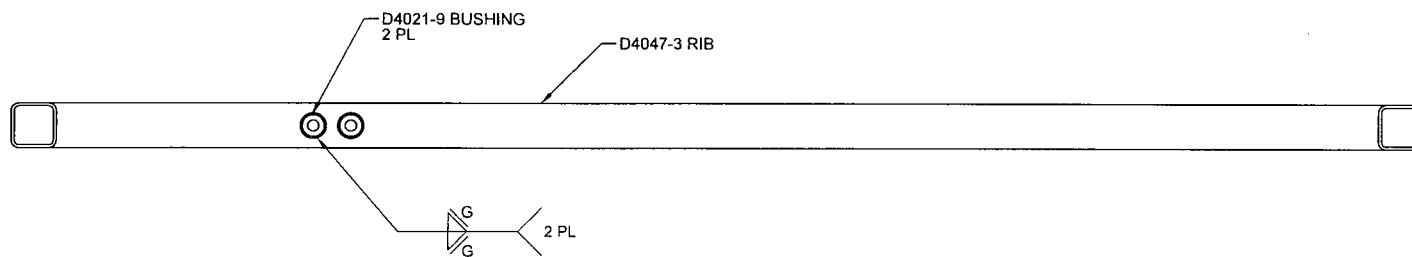
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING

D D C C B B

D4047-043 RIB ASSEMBLY

W0 55251

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

PRELIMINARY ISSUE

RF 10.01.18

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4047	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY	NTS
DATE	10.01.18	COPRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

1

Receiving Report

Date: 8/8/09

Batch No: M129087

Supplier: MAGNA

Dart P/O: 7019

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection 4619 Yes No N/A
 Work Order 4619 Yes No N/A
 N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 EC

Production/Admin:

Date: 08/09/09

Location:

Received/Costing RCP 8763

Initial: EC



Magna Stainless division de CSM Inc.
525 Meloche Ave., Dorval (Québec) H9P 2W2
Tél.: (514) 631-1211 • Fax: (514) 631-0013
Sans frais/Toll free: 1-800-363-6646

ISO 9001-2000

Nº FACTURE / INVOICE NO.

164382

VENDU À - SOLD TO
DART
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO
K6A 1K7

EXPÉDIÉ À - SHIPPED TO

MEME - SAME

Sub-Total
G.S.T.

140.00
7.00

**RAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ Dû.
LE PRÉSENT CONTRAT SERA RÉGÉ PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
YANT PRIS NAissance DANS LE DISTRICT JUDICIAIRE DE MONTREAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.**

TOTAL

147.00

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Sep 2, 2008	Page 1
Receipt Number RCP00008763	

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007019

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304TS0750W049	304 SQ Tube .75x.75x. MATERIAL: AISI 304/316 SS SQUARE TUBING B/N109087	100.0000	f	1.400000	140.00	Sep 02, 2008

Comments:

MAGNA
INOXIDABLE

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDÉ
SALES ORDER

0174394

DU A /
TO:

LIVRÉ A /
SHIP TO:

DART AEROSPACE LTD
270 ABERDEEN STREET
LAWKESBURY
ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

N° DE COMMANDE / SALES ORDER	CODE DU CLIENT / CUSTOMER CODE	N° D'ACHAT DU CLIENT / CUSTOMER PURCHASE ORDER	N° DE TÉLÉPHONE DU CLIENT / CUSTOMER TELEPHONE NUMBER	N° DE TÉLÉSCOPIEUR DU VENDEUR / SELLER FAX NUMBER			
				0174394	DART	7019	613 632-5200
DU VENDEUR VIA / SHIP VIA	CONDITIONS / TERMS	DATE COMMANDEE / DATE ORDERED	DATE REQUISE / DATE REQUIRED	DATE DÉLIVRÉE / DATE DELIVERED	DU VENDEUR / SELLER		
NIR:R-557065-1	NET 30	Aug-26-08	Aug-29-08		15 26 EB		
N° DE CONTRÔLE DE QUALITÉ DU CLIENT / BOUTS / CUSTOMER QUALITY CONTROL / BOLTS		N° DE CONTRÔLE DE MAGNA REQUIS / MAGNA QUALITY RELEASE REQ'D		N° DE PREPARATION / PREP. NO.		N° DE PÉCEVOIR / RECEIPT NO.	
QUALITÉ DU VENDEUR / SELLER QUALITY	UNITS / UNIT	NO. DE COULEE / HEAT NUMBER	DESCRIPTION	DATE DÉLIVRÉE / DATE SHIPPED	PRICE PAR / PRICE PER	INSTRUCTIONS DE L'USINE / FACTORY INSTRUCTIONS	
5	PCS	TUYU2384	304 180 GRIT 3/4" SQ 18GA X 20	100/474	✓	5 pcs	CK358 C88/09
TOTAL :							
Nbre de paq. NUMBER OF BOL'S		MTR-AVEC COMMANDE MTR'S-WITH ORDER <input checked="" type="checkbox"/>		POSTE MAIL <input type="checkbox"/>	TÉLÉSCOPIEUR FAX <input type="checkbox"/>	LBS	
PACKING SLIP / BON D'EMBALLAGE							

age: 1

11:28:12 20080826

N° DE COULEE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATERIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISION 'E' - 07/07 - FORM 8006



WINNER STAINLESS STEEL TUBE CO., LTD

ORIGINAL



ADDRESS: 3RD INDUSTRIAL PARK, XIAOBU VILLAGE, HUASAN
TOWN, HUADU DISTRICT, GUANGZHOU, P.R.C.
TEL: +86-20-86847851 FAX: +86-20-86941744

MILL TEST CERTIFICATE

Customer:

Issued Date: 2006/10/12

Order No.: 119

Certificate No.: GUL-F684
celesley

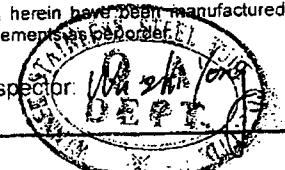
Article: Stainless steel mechanical structures welded tube						Specification: ASTM A554-03							
Item No.	Size	Length	Qty, Pcs	Net Weight	Type	Heat No.	Annealed Temperature (°F)		Hold Time (minute)	Cooling	Surface Finish	Hydrostatic Test (psi)	ET
6~7#	3/4"SQx18GA	20'	200	816.86	MT304	TU-YU238460	—	—	—	—	180Grit	—	—
8#	3/4"SQx18GA	20'	48	196.05	MT304	TU-YU238460	—	—	—	—	180Grit	—	—
9~12#	3/4"SQx16GA	20'	400	2145.80	MT304	TU-YU238951	—	—	—	—	180Grit	—	—
13#	3/4"SQx16GA	20'	27	144.84	MT304	TU-YU238951	—	—	—	—	180Grit	—	—
14#	3/4"SQx16GA	20'	19	101.93	MT304	TU-YU142400	—	—	—	—	180Grit	—	—
Chemical Composition (%)								Mechanical Test					
	C	Mn	P	S	Si	Ni	Cr	Mo	T. S. (Ksi)	Y. S. (Ksi)	Elongation(%)	Flattening	
MIN						8.00	18.00	—	≥75	≥30	≥35	≤2/3D	
MAX	0.080	2.00	0.040	0.030	1.00	11.00	20.00	—					
6~7#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
8#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good	
9~12#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
13#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good	
14#	0.023	1.41	0.035	0.007	0.44	8.09	18.21	—	92	50	51	good	

Remarks:

1. Corrosion test: as per ASTM-A262, Practice E: accepted.
2. Dimensions & Visual: good.
3. Materials are free from mercury contamination.

We, Winner Stainless Steel Tube Co., Ltd., hereby certify that the products described herein have been manufactured in accordance with the standards and specifications specified as above and meet the requirements of the order.

Q. C. Manager/Work Inspector:



53693/310453385

DART**Purchase Order**

Date	Page
Aug 25, 2008	1
Purchase Order Number PO00007019	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Aug 25, 2008	N30	yours	Aug 26, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/26/2008	No	6.406250	sf	2,050.00
320.0000	M304S22GA	304/316 .032 Sheet Comments: AS ABOVE	8/26/2008	No	3.281250	sf	1,050.00
100.0000	M304TS0750W049	304 SQ Tube .75x.75x.0 Comments: MATERIAL: AISI 304/316 SS SQUARE TUBING	8/26/2008	No	1.400000	f	140.00
80.0000	M6061T6A1000W125	6061T6 ANGLE 1.00 x 1 Comments: MATERIAL: 6061-T6/T6510/6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8	8/26/2008	No	0.675000	f	54.00
200.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	8/26/2008	No	1.500000	f	300.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Comments:	Tax Summary: GST ONT PST	179.70 0.00	Less: included tax	0.00	
			Subtotal		
			Total tax	3,594.00	
			Total purchase order in CAD Dollars	179.70	
				3,773.70	

Entered By: *CL* CLAVOIE

Approved By: *CL*